

Work Order ID 96377 -2
Monday, January 28, 2013 10:02:07 AM

96377

Item ID: D3393-041
Revision ID:
Item Name: Battery Lock Assembly
Start Date: 1/25/2013 Start Qty: 4.00
Required Date: 1/28/2013 Req'd Qty: 4.00
Reference: rework to keyed alike

split 2

Accept

N9000040100

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: Process Plan: MUX
QC:

Date: 13-01-28 Tooling:
Date: SPC (Y/N):

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3393
170
170
Small Fab
Small Fab

Rev A

0.00
0.00

Memo
PULL FROM STOCK D3393-041 X 4 B86828
REWORK TO KEYED ALIKE

4 0 FF 13-01-29

180
180
QC
Quality Control

QC'S- Inspect part completeness to step on W/O

Memo

0.00
0.00
AS
15
13-01-29

4 0 FF 13-01-30

190
190
Large Fab
Large Fab

SS 316 wire M122357

Memo

0.00
0.00

2
2 EL 13-1-29



Work Order ID 96377

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96377

Page 2

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Revision ID:

Item Name: Battery Lock Assembly

Start Date: 1/25/2013 Start Qty: 4.00

Required Date: 1/28/2013 Req'd Qty: 4.00

Reference: rework to keyed alike

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

200

QC9- Inspect visual per QSI004- Fusion Welds

0.00

200

QC

Memo

0.00

Quality Control

② 13-01-29



210

Identify as per dwg & Stock Location:

0.00

210

Packaging

Memo

0.00

Packaging

PP 95596

1/23/129 ②

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

13/1/29

13-01-29

28
02
24

Picklist Print

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Work Order ID: 96377
 Parent Item: D3393-041
 Parent Item Name: Battery Lock Assembly

Start Date: 1/25/2013

Required Date: 1/28/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3393-041 Battery Lock Assembly		Manufactured	No				Each	0.0000		4			
D3393-1/3 Battery Lock Casing		Manufactured	No				Each	3.0000		4			

if necessary

mf

13-1-20

Location

ST492

87143

95705

Loc Qty

3

3

Loc Code

4

FF 13-01-20

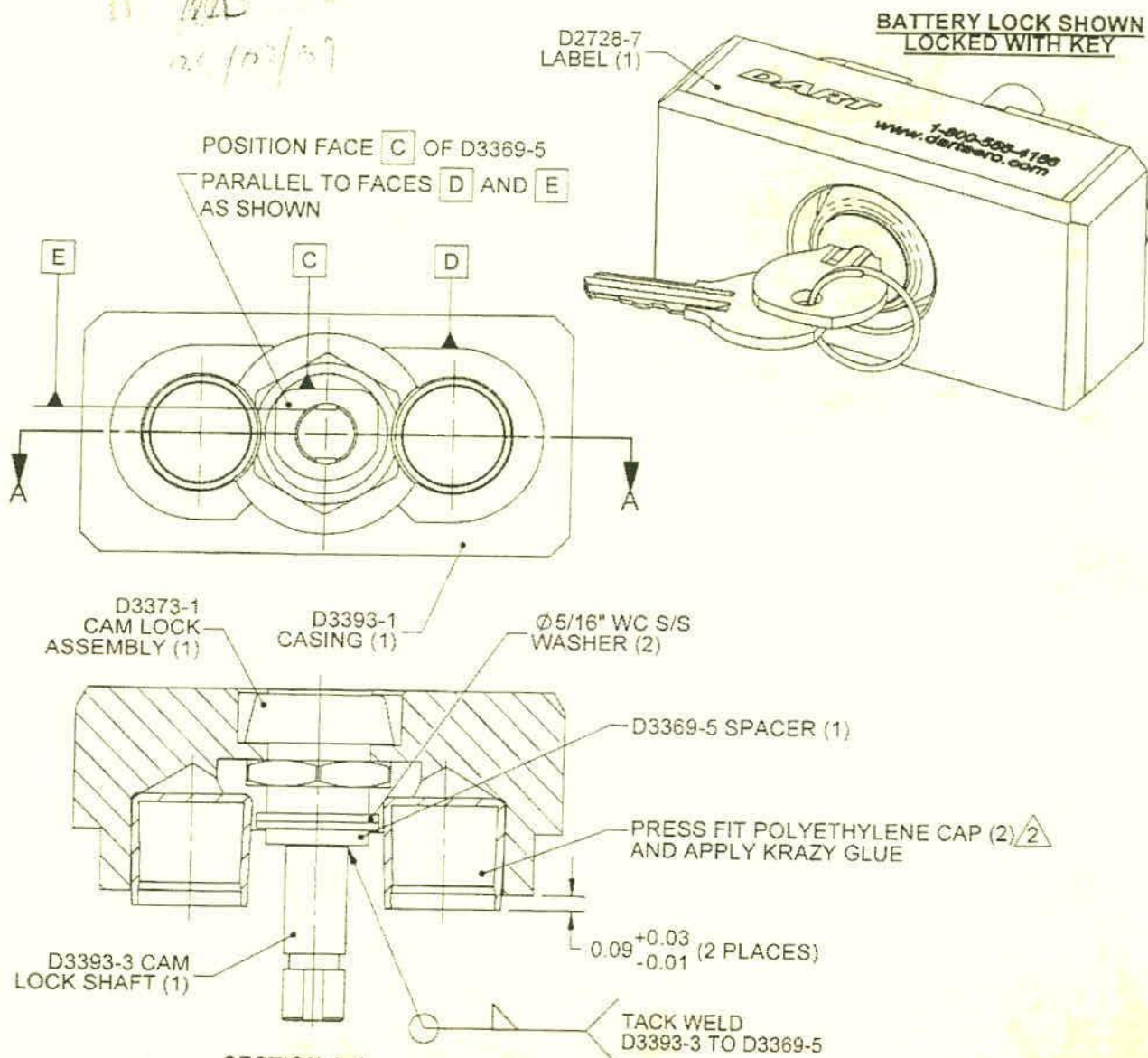
FF 13-01-20





DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 17	APPROVED 18	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
18
25/10/09



SECTION A-A

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

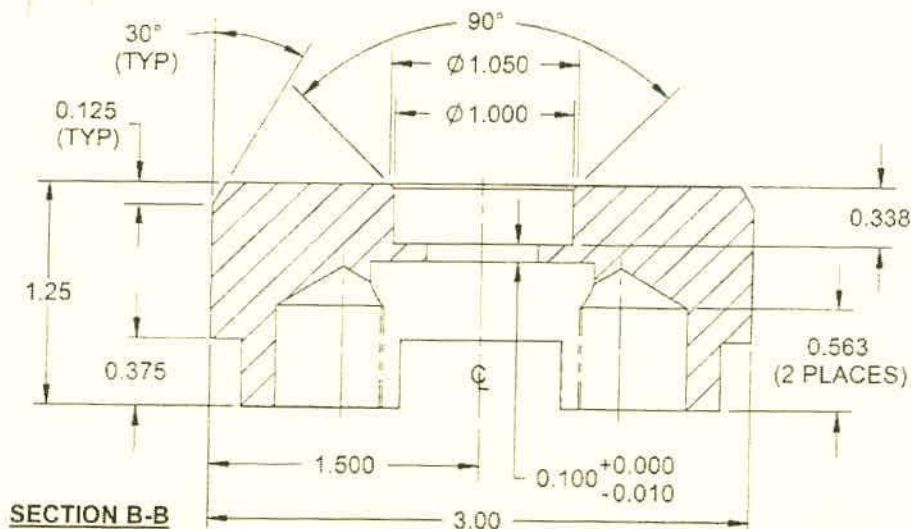
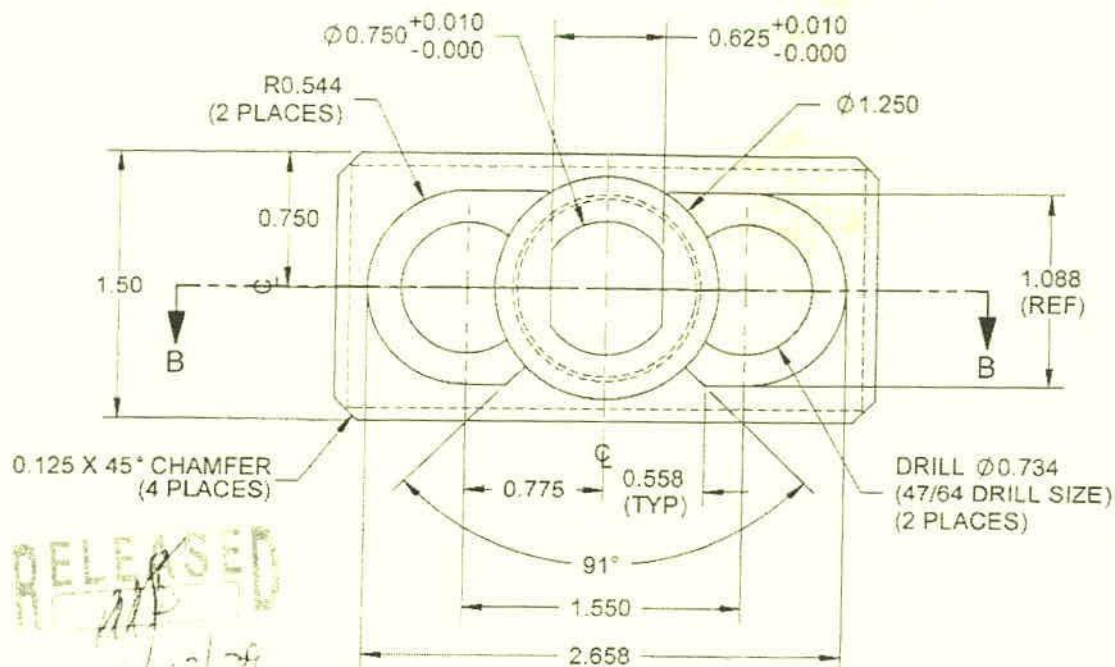
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DESIGN 43	DRAWN BY 3	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 77	APPROVED [Signature]	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09	TITLE BATTERY LOCK		SCALE 1:1



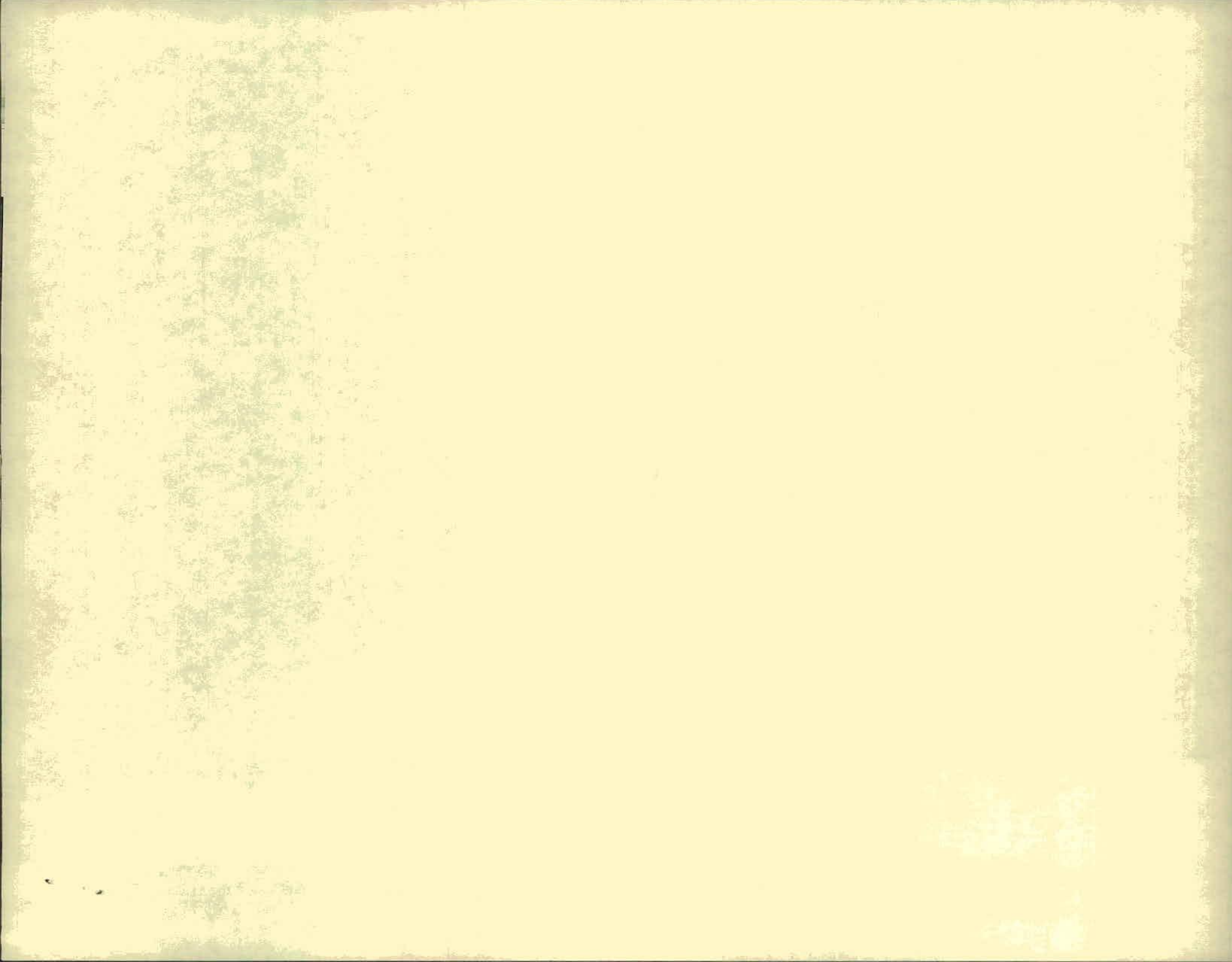
D3393-1 CASING

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

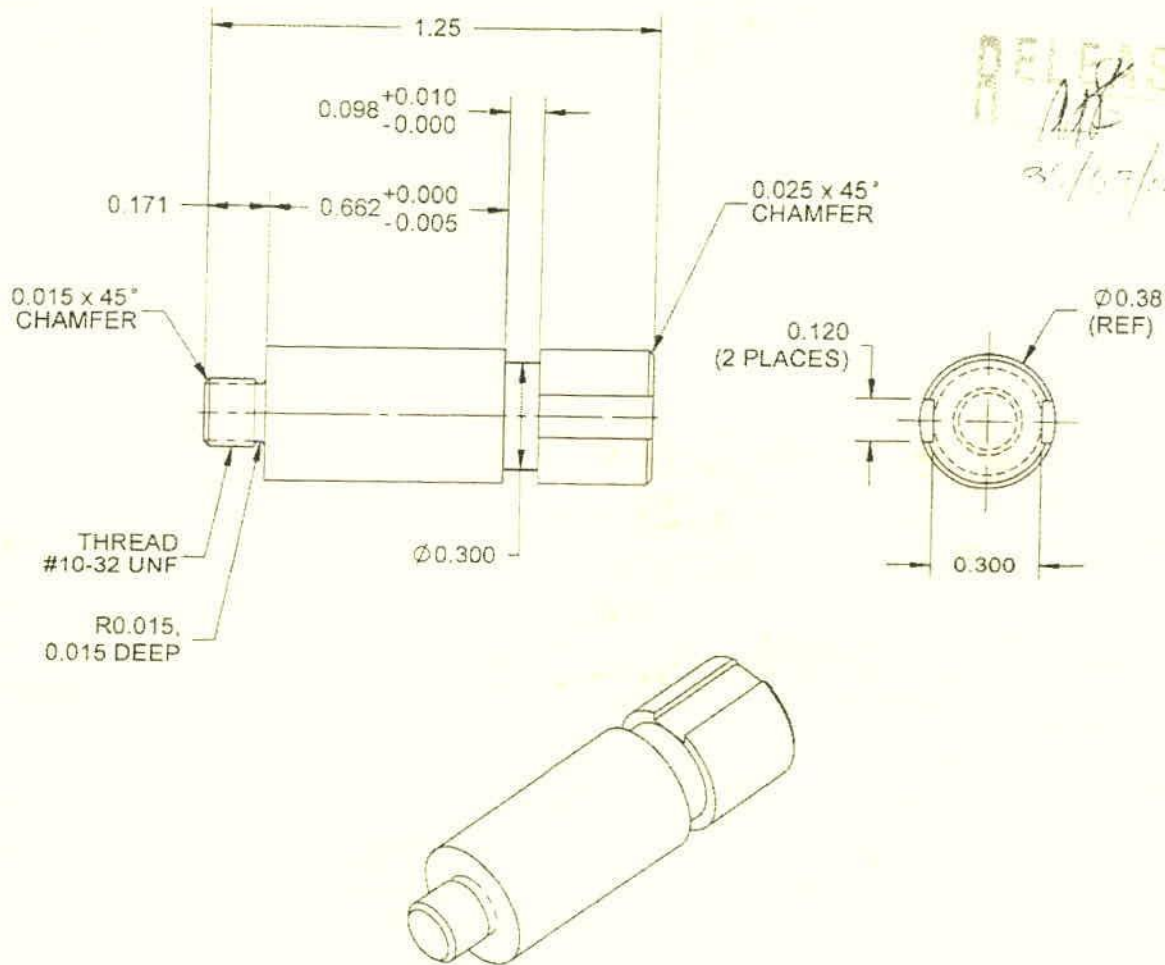
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 3 OF 3
DATE 05.02.09		TITLE BATTERY LOCK	SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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